DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-020043 Address: 333 Burma Road **Date Inspected:** 06-Apr-2010

City: Oakland, CA 94607

OSM Arrival Time: 645 **Project Name:** SAS Superstructure **OSM Departure Time:** 1845 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Liu Hua Jie, Lu Li Qing, Geng Wc WI Present: Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A Yes N/A **Electrode to specification:** No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A **Approved Drawings:**

N/A Yes N/A Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** Orthotropic Box Girder (OBG)

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Assembly, Bay 14, Edge Beam.

During Random Visual in process Inspection, this QA inspector observed ZPMC personnel Heat Straightening Edge Beams Identified as EB3006B & EB3006A. ZPMC QC Li Ming Yang showed Heat Straightening Report HSR # 8262 & 8261 respectively. The attached photographs provide additional detail.

Assembly, Bay 14, 12CE, Deck Panel Diaphragm.

FCAW welding of weld joint DP3030-001-241, 246, 251, 256, 85, 90, 95, 100; located on assembly, Bay 14, 12CE. Welders are identified as 044790; ZPMC Quality Control Inspector (QC) is identified as Li Lu Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2233-TC-U4B-F.

Assembly, Bay 14, 10AW, PP85.5.

During Random Visual in process Inspection, this QA inspector observed fit-up X37-Stiffener at 10AW PP85.

5. The attached photographs provide additional detail.

Assembly, Bay 14, 12BE, Corner Assembly CA3002, Edge plate to Deck plate.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

FCAW welding of weld joint CA3002-004; located on assembly, Bay 14, 12BE. Welder is identified as 066733, 055491; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U4B-F.

Assembly, Bay 14, 12AW, Deck plate (DP3044A) to Deck plate (DP3043A).

SAW welding of weld joint SEG3004*-005; located on assembly, Bay 14, 12AW. Welder is identified as 204730; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-B-U2-F.

Assembly, Bay 14, 12BW, Stiffener for Longitudinal diaphragm.

SMAW welding of weld joint SEG3005M-020, 061; located on assembly, Bay 14, 12BW. Welder is identified as 066038, 067764; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2114-FCM-1.

Assembly, Bay 14, 12AE, Stiffener for Corner Assembly Diaphragm.

FCAW welding of weld joint SEG3001P-188, 187; located on assembly, Bay 14, 12AE. Welder is identified as 055491; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2132-F.

Assembly, Bay 13, Mock-Up for 13AE.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector observed ZPMC carring out Mock-Up for 13AE. This QA inspector noticed ZPMC personnel mounted Bottom panel on the temporary support structure (jig).

This QA Inspector carried out NDE on following

Bay 19, Suspender Bracket.

This QA inspector performs Random Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel (Notification # 005479). This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as

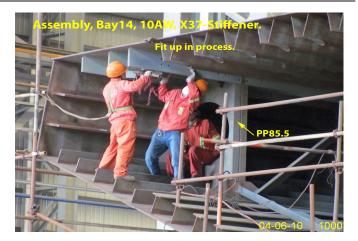
- SB013-064-002, 003, 021, 022, 027, 028.
- SB013-064-057, 058, 063, 064, 029, 030, 065, 066, 023, 024, 059, 060.
- SB013-064-069, 070.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)





Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer